

Date: Tuesday, 12/08/2008 1:01:18 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 41176-2  
 Estimate Number : 13106  
 P.O. Number :  
 This Issue : 12/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : MACHINED PARTS  
 Previous Run : 41075

Drawing Name : CUP

Part Number : D30093  
 Drawing Number : D3009 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 30/08/2008

Qty: 200 Um: Each

Written By :  
 Checked & Approved By : JLD 08.8.12  
 Comment : Est. A 07.12.18 new issue EC  
 Est Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified  
 by:ec

## Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 M304R1000 304 round bar 1.00

Comment: Qty: 0.0503 f(s)/Unit Total: 2.0118 f(s)  
 304/316 SS ROUND BAR  
 Material: AISI304/316 SS 1.00" Ø Round Bar  
 (M304R1000)  
 Batch: 11/8188

2.0 HARDINGE HARDINGE CNC LATHE SMALL

Comment: 1-TURN AS PER FOLIO FA130 & DWG D3009  
 FOLIO REV: A  
 DWG REV: B

2-DEBURR AS REQUIRED

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: ST59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3009-3 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: D Date: 08/09/05  
D3565-1 D3719-041/043  
D135-692-041 QA: N/C Closed: D Date: 08/09/05

NCR: <u>41176</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/6/01	20	Parts were found at inspection local & to be over b1 0.353" as up to 0.378"		Parts are attached with shrink fitting welding 8/6/01				8/6/01
		R.L. Humman error	PH 06.08.02 QSI 042 for B. Reddett	Remachin' parts to correct Dim' as per drawing	8/6/02	8/9/2		8/9/2
				13. Parts scrap. no replace and Retraining employee to make the correct amount of parts as per QSP019. Recommend scrap	8-02 08/09/02			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 41176

Part Number: D30093

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/03 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

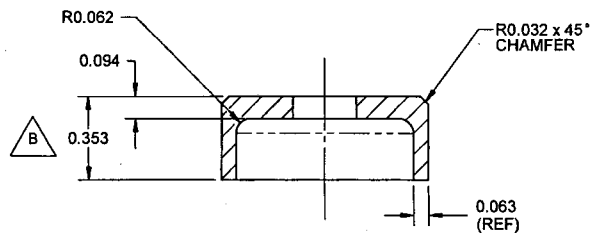
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

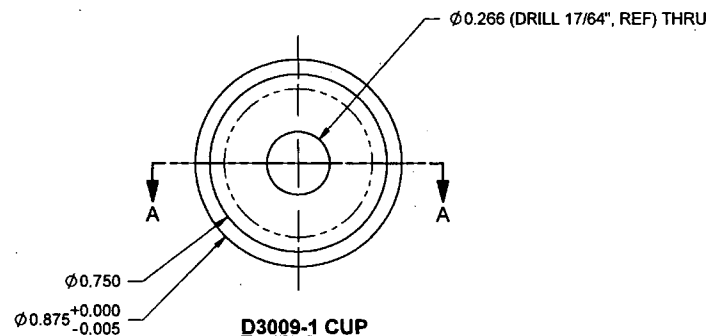
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





SECTION A-A



D3009-1 CUP

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 44174

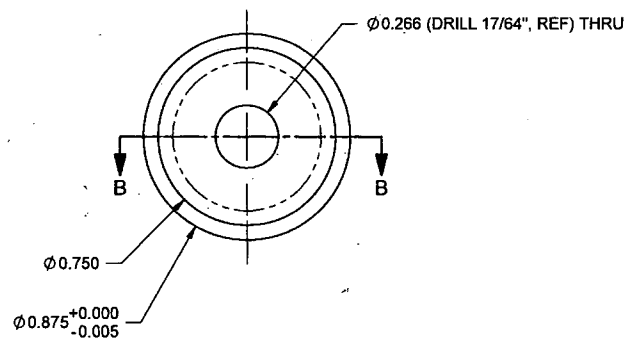
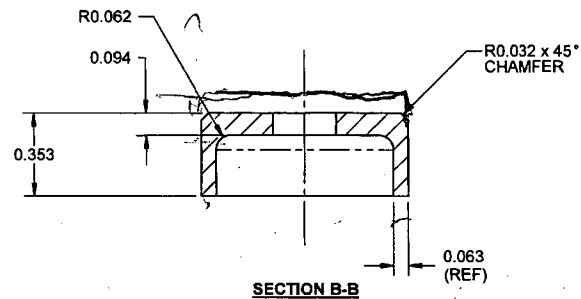


NOTES:

- 1) MATERIAL: AISI 1018-1025 ROUND BAR (REF DART SPEC M1018-R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

RELEASED  
68-01-07

B	REDRAW/REFORMAT DWG, D3009-1 MAT'L WAS 1010-1025 NOW 1018-1025 (A8), 0.353 WAS 0.363 (D7), Ø0.266 WAS Ø0.257 (C5), ADD D3009-3 (SHEET 2)	CP	07.12.12
A	NEW ISSUE	RF	01.03.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.12		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3009 TITLE CUP SCALE 2:1 REV. B SHEET 1 OF 2 <small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



**D3009-3 CUP**

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WITHOUT NOTICE  
WORK ORDER  
NO. 41172

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR  
(REF DART SPEC M304R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

433  
- 094  
959

**RELEASE**  
08.01.07.10

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3009</b>	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 2
APPROVED		<b>CUP</b>	SCALE
DE APPR.			2:1
DATE	07.12.12	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	